

# Work Order ID 53247

October 28, 2009 1:39:19 PM



Page 1

Item ID: D3827-041

Accept



Setup Start



Revision ID: A

Stop



Item Name: Rib Assembly (Inboard)

Start Date: 29/10/2009 Start Qty: 6.00



Cust Item ID:

Required Date: 04/11/2009 Req'd Qty: 6.00



Customer:

Reference:

Approvals:

Process Plan:

*PS*

Date:

*09/10/28*

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D3827

Rev A

100

0.00



Large Fab

Large Fab

Memo

0.00

*SAD 09-11-03*

*(b)*

- 1- cut D3827-1 rib as per dwg D3827
- 2- drill holes using DT9435 jig and open to finish size as per dwg D3827
- 3- c'sink as per dwg
- 4- remove identification markings
- 5- deburr

110

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

*2) 801/1/03*

*(46)*

*f*

Quality Control

**Work Order ID 53247**

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Page 2

Item ID: D3827-041

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Start Date: 29/10/2009 Start Qty: 6.00



Cust Item ID:

Required Date: 04/11/2009 Req'd Qty: 6.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120		0.00							
	Large Fab								
Large Fab	Memo	0.00							
Large Fab	1- weld bushing in rib as per dwg D3827 Batch: <u>2109213</u> 2- grind weld flush 3- deburr if necessary ✓	A/R ER316 S.S. Rod							
130	QC10- Inspect visual per QSI004- ground welds	0.00							
QC	Memo	0.00							
Quality Control									
140	QC5- Inspect part completeness to step on W/O	0.00							
QC	Memo	0.00							
Quality Control									

2109/11/09

x6

x

27 Serial 04

x6

x

27 Serial 04

**Work Order ID 53247**

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Page 3

Item ID: D3827-041

Accept



Setup Start



Revision ID: A

Stop



Item Name: Rib Assembly (Inboard)

Start Date: 29/10/2009 Start Qty: 6.00



Cust Item ID:

Required Date: 04/11/2009 Req'd Qty: 6.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

150

Identify as per dwg & Stock Location *Basket*

0.00



Packaging

Memo

0.00

*PD 09.11.04 (6)*

Packaging

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

*09/11/04**PD 09-11-4*

# Picklist Print

October 28, 2009 1:39:25 PM

Page 1

Work Order ID: 53247

Parent Item: D3827-041RevA

Parent Item Name: Rib Assembly (Inboard)



Comments:

Start Date: 29/10/2009

Required Date: 04/11/2009

Start Qty: 6.00

Required Qty: 6.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3759-1RevA		Manufactured	No			100	Each	56.0000	18.0000			
												
Bushing												

Warehouse Loc Qty Loc Code

Location

Main Warehouse

WA

56

51136

20

51473

36

M304TS0.750W.065

Purchased

No

100

f

196.1893

50.5263



304 SQ Tube .75x.75x.065W

Warehouse Loc Qty Loc Code

Location

Main Warehouse

WA

196.1892947

112398

196.189295

13x 09/11/04

SAD 09-11-04

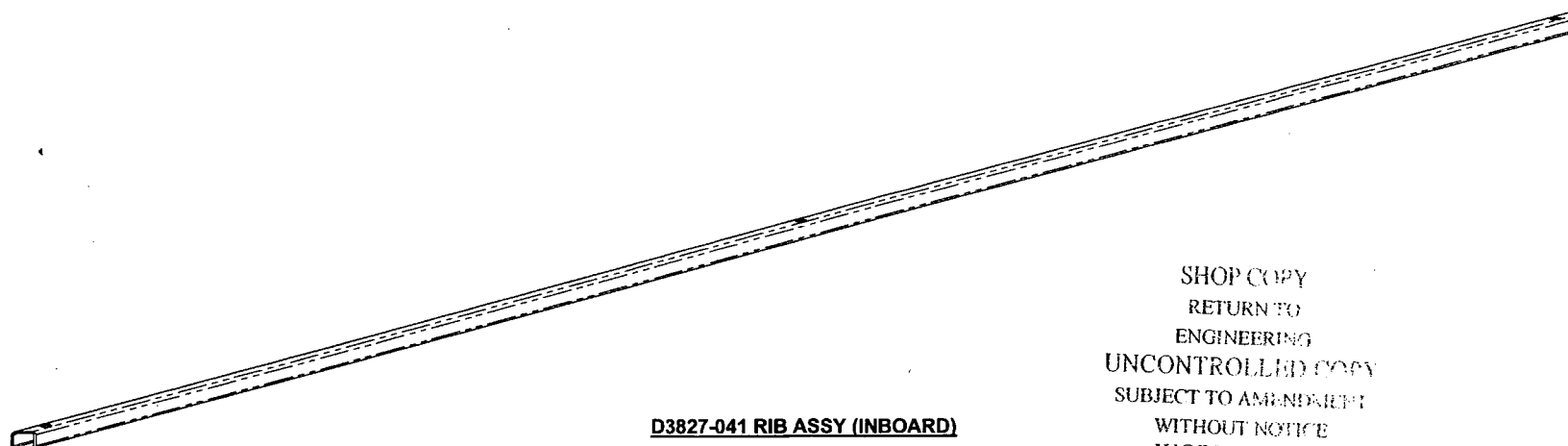
50.5263

03x6 = 18sq(4)

Scrap End Bar 1.8sq(4) of B# 112398

8 7 6 5 4 3 2 1

ITEM	QTY -041	P/N	DESCRIPTION
1	X	D3827-041	RIB ASSY (INBOARD)
2	3	D3759-1	BUSHING
3	1	D3827-1	RIB



**D3827-041 RIB ASSY (INBOARD)**

SHOP COPY  
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SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 53247

*BP 09-10-28*

**RELEASED**  
*08/11/14*

NOTES:  
1) MATERIAL: N/A  
2) FINISH: NONE  
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED  
4) UNITS: INCHES UNLESS OTHERWISE NOTED  
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX  
6) IDENTIFICATION: N/A  
7) WEIGHT: 4.59 lbs

A	NEW ISSUE	MB	08.09.23
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	08.09.23		

<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. <b>D3827</b>	REV. A SHEET 1 OF 3
TITLE <b>RIB ASSY (INBOARD)</b>	SCALE NTS
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8 7 6 5 4 3 2 1

8 7 6 5 4 3 2 1

D

D

C

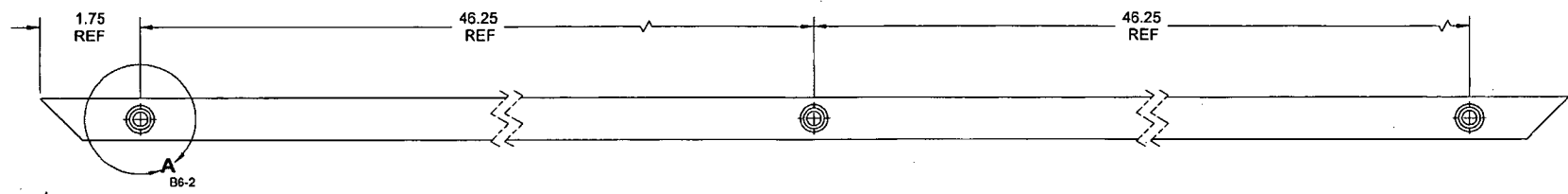
C

B

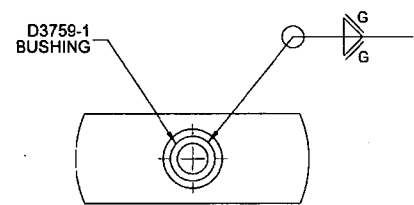
B

A

A



**D3827-041 RIB ASSY (INBOARD)**



**DETAIL A**  
SCALE 2X  
C7-2  
3 PL

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**RELEASED**  
*08/11/18 N/A*

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MFG. APPR.	<i>MA</i>	D3827	SHEET 2 OF 3
APPROVED	<i>MA</i>	TITLE	SCALE
DE APPR.	<i>MA</i>	RIB ASSY (INBOARD)	NTS
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8 7 6 5 4 3 2 1

$\phi 0.375^{+0.020}_{-0.000}$  THRU  
 $\phi 0.49 \times 100'$  CSINK  
 ON BOTH SIDES  
 TYP

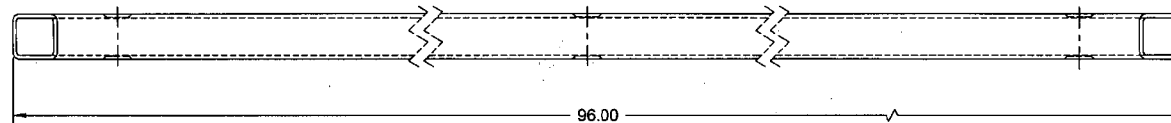
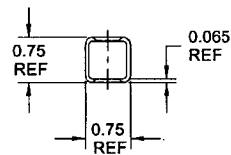
0.375

0.75 X 45° CHAMFER  
 2 PL

46.250

46.250

1.750



**D3827-1 RIB**

**NOTES:**

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.065 WALL  
REF. DART SPEC. M304TS.0.75W0.065
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 4.55 lbs

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 NO. 53247

**RELEASED**  
08/11/12

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